

Date: Tuesday, 3/20/2007 2:36:12 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE BILLET  
Job Number : 31389 - 2  
Estimate Number : 10035  
P.O. Number : N/A Part Number : D6101007  
This Issue : 3/20/2007 S.O. No. : N/A Drawing Number : D6101 REV A  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : MACHINED PARTS Drawing Revision : A  
Previous Rtn : 25355 Material : N/A  
Written By : Due Date : 6/1/2007 Qty: 200 Um: Each  
Checked & approved By : 07.03-20  
Comment : Est. A: 01.05.04 New Issue EC

## Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description:

1.0

PG

PURCHASING

Comment: PURCHASING

Issue P/O:

3385

CLO 7/03/22

a) Description: Aluminum billet

b) 7.750" x 8.250" x 2.50" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 7.750" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

200

2.0

D6101007P

7075-T7351 8.25X7.75X2.5

Comment: Qty.: 1.0000 Each(s)/Unit Total: 200.0000 Each(s)  
7075-T7351 8.25X7.75X2.5

3.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

4.0

QC6

DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

07/09/15

50



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 31389

Part Number: D6101007

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

JMA 07/09/15 50

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 09/09/17 (50)

Job Completion



CLO 7/09/17



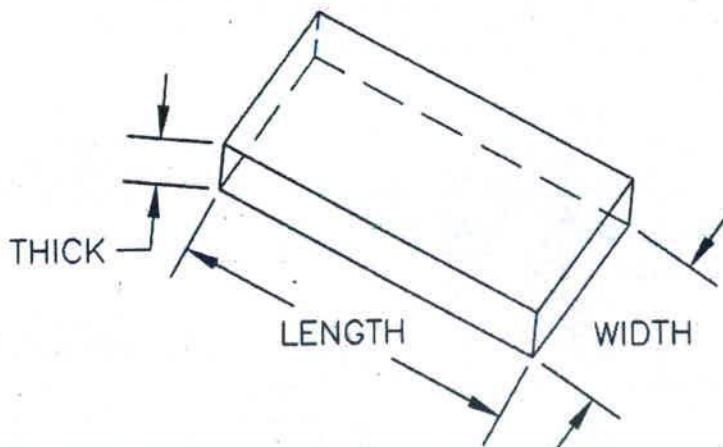




DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED JS	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING

RELEASED  
01.04.23 CP



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.100 Length

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31389

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31 555699 996487 01

A.M. CASTLE &amp; Co. (Canada) Inc.

EXPÉDIE 12 SEP. 2007

O. REQUISITION CLIENT-CUSTOMER REQUISITION NO.

NO. COM. CLIENT-CUST. ORD. NO.

3385

COMPTÉ-ACCT.

VEND. SLS

TERR.

EXPÉDIE PAR-SHIP VIA

91037

200

40

TRUCK

MANITOULIN

CHÉTEUR-PURCHASING AGENT

LINDA LACELLE

TELEPHONE

613 632-3336

H/C

TAXE

NO. COM. ORD.

1

C/C

REGION LIVRAISON-DEL. ZONE

F.A.B.-F.O.B.

PREPAID

BILL

NO. FEVILE/EMBALLAGE-B/L NUMBER

VRÉ A-SHIP TO:

VENDU A-SOLD TO:

DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY

ON K6A 1K7

INFORMATION CRÉDIT-CREDIT INFORMATION

RC2 SEE FRANCE STATUS

ROUTE

01\*NL-09/0

31-NL-09/0

INSTRUCTIONS/LIVRAISON-DELIVERY

INC-H60156

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

DESCRIPTION - ITEM 1

2.5000 PLATE 7075-T7351 ALUM 8.25" X 7.75"

BLACK W/RED STRIPE

CERTIFICATE OF CONFORMANCE

INSTRUCTIONS

TOL: +.025"/-.000"

THICKNESS TOL.: +.030"/-.000"

GRAIN TO RUN ALONG 7.75"

PRIOR DIST/ORD: 01 996487

COULÉE INFO-HEAT INFO QTE-QTY

401533AS

QTE/UNITE COM.-ORDERED

50 PCS

PCES/PO COM.-ORD.

POIDS COM.-WT. ORDERED

808

BALLOTS-BUNDLES

PCES/PO EXP. SHIP.

POIDS EXP.-WT. SHIPPED

1 50

808

FORME-SHAPE

I.A.C.

6879

36.360SQF

INSTRUCTIONS (CONT'D.)

50 x 8.25" x 7.75"

26

ENT.-W

DESCRIPTION - ITEM 2

TERMS AND CONDITIONS  
OF SALESEE DISCLAIMERS AND LIMITATIONS  
ON THE REVERSE SIDE

INSTRUCTIONS

1 Box  
W/SSS704

COULÉE INFO-HEAT INFO QTE-QTY

INSTRUCTIONS (CONT'D.)

QTE/UNITE COM.-ORDERED

PCES/PO COM.-ORD.

POIDS COM.-WT. ORDERED

BALLOTS-BUNDLES

PCES/PO EXP. SHIP.

POIDS EXP.-WT. SHIPPED

FORME-SHAPE

I.A.C.

ENT.-W

DESCRIPTION - ITEM 3

ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED  
ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY  
RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF  
SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN  
10 DAYS WHEN CREDIT IS REQUESTED.

INSTRUCTIONS

COULÉE INFO-HEAT INFO QTE-QTY

INSTRUCTIONS (CONT'D.)

QTE/UNITE COM.-ORDERED

PCES/PO COM.-ORD.

POIDS COM.-WT. ORDERED

BALLOTS-BUNDLES

PCES/PO EXP. SHIP.

POIDS EXP.-WT. SHIPPED

FORME-SHAPE

I.A.C.

ENT.-W

LE MOULÉE-NAME (PRINT ONLY)

RECU PAR-RECEIVED BY

DATE RECU-  
DATE RECEIVED

FEVILE D'EMBALLAGE - PACKING SLIP





## SHIP TO:

A M CASTLE & CO  
3400 NO. WOLF ROAD  
FRANKLIN PARK, IL 60131

## SOLD TO:

AM CASTLE & CO  
3400 NO. WOLF ROAD  
FRANKLIN PARK, IL 60131

# KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number  
4103569

CUSTOMER PO NUMBER: 01-84658		WORK PACKAGE:		CUSTOMER PART NUMBER: 6879 A97075-60		SHIP RUN/LOAD ID: 101025/16		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1052032	LINE ITEM: 1	SHIP DATE: 26-JUL-2007	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: MILL FINISH PLATE			
WEIGHT SHIPPED: 7126 LB	QUANTITY: 4 PCS EST.	B/L NUMBER: 2013762		GAUGE: 2.5000 IN		WIDTH: 48.500 IN		LENGTH: 144.500 IN	

### Certified Specifications

AMS 4078/RevG  
ASTM B 209/Rev06  
BSS 7055/RevA  
DPS 4.713/RevN/AmdAF  
GSS16100/RevG

AMS-QQ-A-250/12  
ASTM B 594/Rev06  
CMMP 025/RevR  
EAC MS1011/RevD  
MMS 159/RevN

AMS-STD-2154  
BAC 5439/RevH  
CSTI 006/RevC  
GAMPS 9101/RevB  
PS 21211/RevK

Test Code: 4297

### Test Results

Lot: 401533A5 Cast 984

Drop 61

Ingot 2

(ASTM E8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	70.1 : 70.1 (483 : 483)	58.8 : 59.1 (405 : 407)	10.8 : 11.0

(ASTM E1004)

Conductivity %IACS :	41.0 Min	41.1 Max
(MS/M) :	23.8 Min	23.8 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.11	0.21	1.5	0.02	2.5	0.20	5.7	0.03	0.01	0.01	TOT 0.04

CASTLE METALS CORP.

DATE RCVD 7/30/07

IAC 6879

APPROVED BY



**KAISER  
ALUMINUM**

Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2586

**CERTIFIED TEST REPORT**

Serial Number

4103569

Lot: 405629A7 Cast 984 Drop 87 Ingot 3

(ASTM E8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	70.3 : 70.6 (485 : 487)	59.1 : 59.1 (407 : 407)	10.4 : 10.9

(ASTM E1004)

Conductivity %IACS :	41.8 Min	41.8 Max
(MS/M) :	24.1 Min	24.2 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	TC
Actual	0.11	0.20	1.5	0.02	2.5	0.19	5.6	0.02	0.01	0.01	TC

**ALLOY LIMITS**

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EAC
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TC

**Aluminum Remainder****TEST NOTES**

Metal represented by this test report was immersion ultrasonically tested from one side and meets the Class A and Class B requirements of all specifications referenced on this test report.

**CERTIFICATION**

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. A IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM & CHEMICAL CORPORATION LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE SHALL BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

**BILL POYNOR, LABORATORIES SUPERVISOR**
